

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013243**Date Inspected:** 12-Mar-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gang Liang Zhu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

FACEADE YARD:

This QA Inspector performed Randomly Visual Inspection and Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL- 6028 (MT) report for this date. The member is identified as Pad eye of 47.6M Skin E. The weld designations reviewed are as follows.

SL3-47.6M-7

NDT Notification No-005320

This QA Inspector observed the following work in progress:

BAY 11

Repair Welding

This QA Inspector observed ZPMC qualified welding personnel identified as 049099. Perform Shielded Metal Arc Welding (SMAW) on West Tower lift 4 A/B corner joint. Joint identified as WSTL4-2B/L-59B. ZPMC CWI Identified as Gang Liang Zhu, with Critical welding repair report CWR-T-CWR603. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) - Repair.

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Sub-Merged Arc Welding (SAW):

Weld joint # 7-1B located on Strut Connection Plate ND1 – SA4 – 68 – 143. Welder is identified as 042915. ZPMC Quality Control (QC) Inspector is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3221 – Tc – U5 – S – 1.

Weld joint # 1-21B located on Strut Plate SD1 – STSA4 – 5 – 131. Welder is identified as 044560. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – T – 4221 – B – U3c – S – 1.

BAY 10

Flux Core Arc Welding (FCAW):

Weld joint # 62 located on North Tower Lift-4 B/C Corner Diagonal Plate NSTL4 – 3K/L. Welder is identified as 066165. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Weld joint # 74 located on North Tower Lift-4 C/D Corner Diagonal Plate NSTL4 – 3K/L. Welder is identified as 067876. ZPMC Quality Control (QC) Inspector is identified as Li Peng Fei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest phone: 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
